3-Gun Champion Tony Holmes

ROTH CONCEPT INNOVATIONS, LLC

XM2XI

INTEGRATED BENELLI M2

Owner Use-Maintenence Manual

ROTH CONCEPT INNOVATIONS LLC (RCI)

XM2XI 26 Integrated XRAIL System – Use-Maintenance.

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WARNING! **It is crucial that user(s), in addition to this manual, read and understand all material related to this firearm contained in the factory provided Benelli M2 "USE- MAINTINENCE" manual that accompanied this firearm… most importantly, any information regarding safe gun handling. RCI will refer to several areas within that manual to review through the description of this manual.**

1. Introduction

Thank you for purchasing the new M2XI 26 Benelli Integrated XRAIL System by RCI. With this conversion shotgun there are a few things to learn so please take the time to study all of the following information. This is a high performance shotgun that has been developed for Open Class division 3 gun, USPSA, and IPSC competition. This product was not developed for Hunting or Military-Law Enforcement use, although it may have some application in those fields. Keep in mind this is a "Race gun". As with a lot of "Race Guns", this product is "Ammunition Sensitive" for maximized performance. Always make sure to use ammunition that fully cycles the action. What does this mean? It means that NOT ALL AMMUNITION will cycle the gun. Since there are thousands and thousands of 2 ¾" 12 gauge ammunitions, we have done all of our development around certain types of rounds that are most common in the USA.

2. Description

The M2XI is pre assembled and ready to use AFTER you have studied all the written information and manuals about the firearm that are included. This is merely informational material regarding the maintenance and use of the product. Disassembly by unauthorized personnel beyond this written information will void the factory warranty.

The M2XI 26 is a high capacity shotgun that integrates the XRAIL System with the Benelli M2 12 Gauge Shotgun. This is a semi automatic shotgun that has a 25+1 round capacity of 2 3/4" Shot shell.

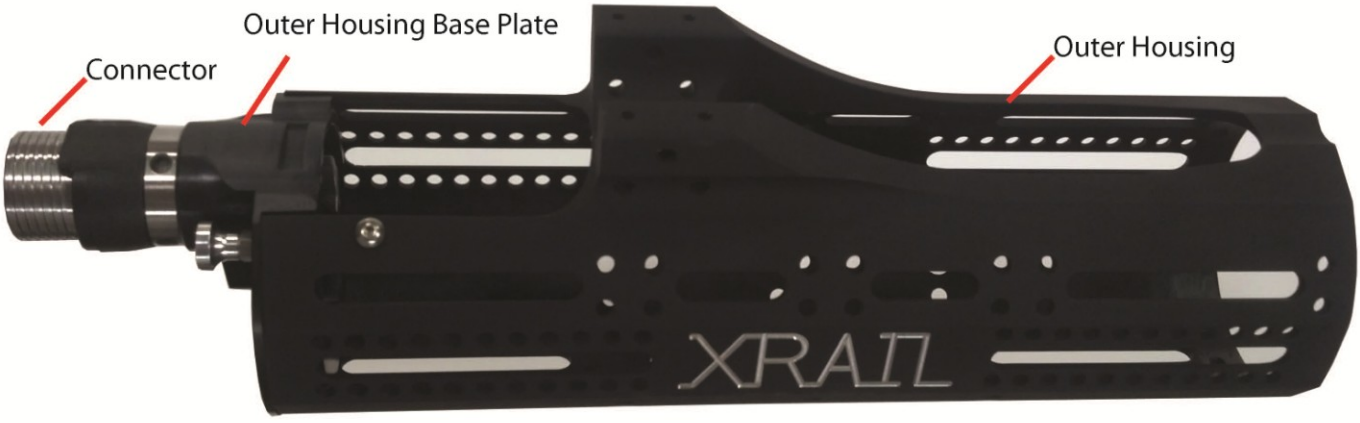
The M2XI 26 has three basic components, the Benelli M2 12 Gauge, the XRAIL Outer Housing assembly, and the XRAIL Inner Tube Housing assembly.

A. The Benelli M2 with Comfortec Stock

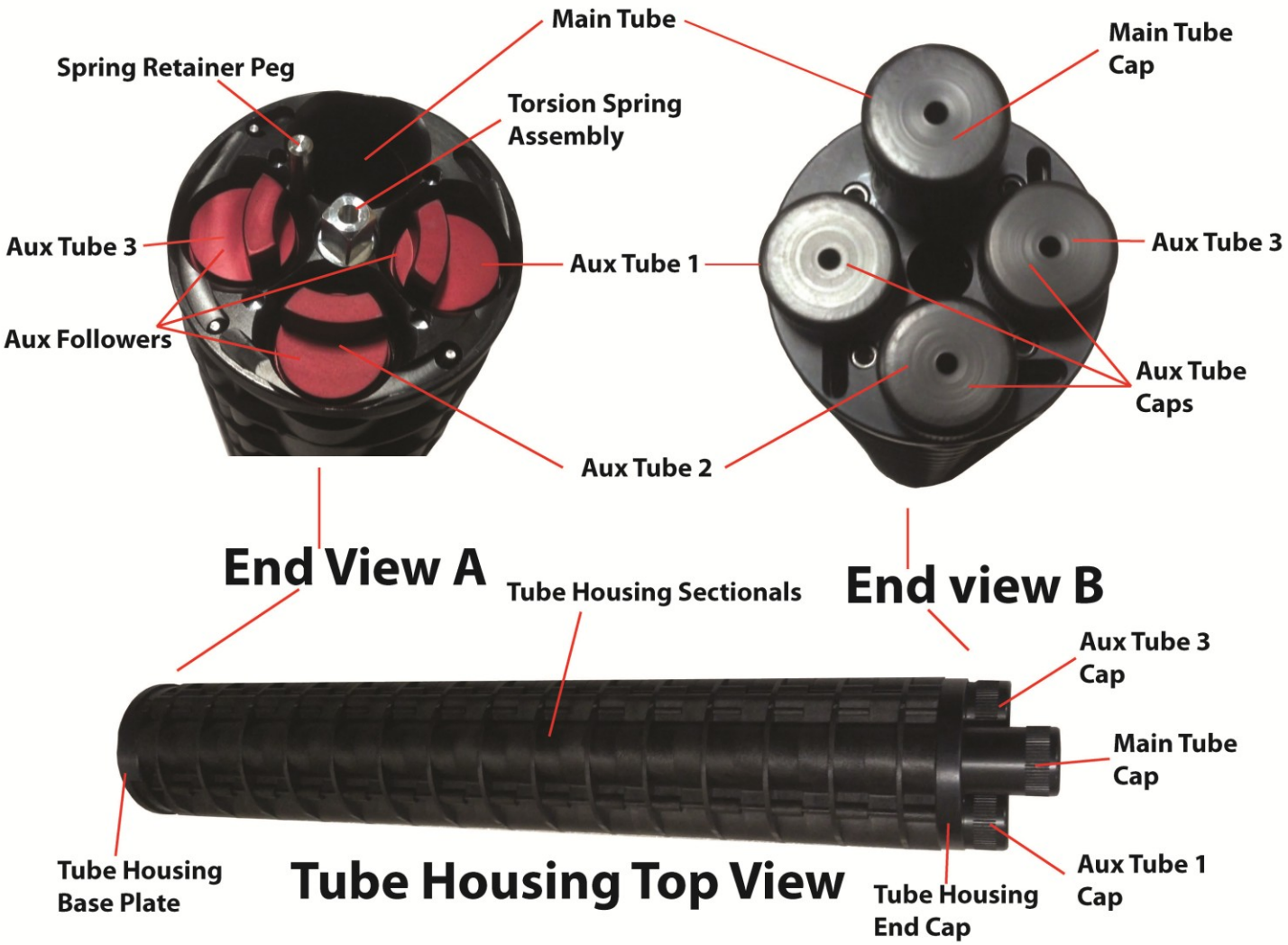
For the Benelli M2 12 gauge information, refer to the Benelli owner/user manual. User must read and understand all the information in Benelli M2 manual that we included with the firearm **before using the gun**.

B. The Outer Housing - Diagram 1

Outer Housing-Diagram 1-A



C. The Inner Tube Housing-Diagram 2



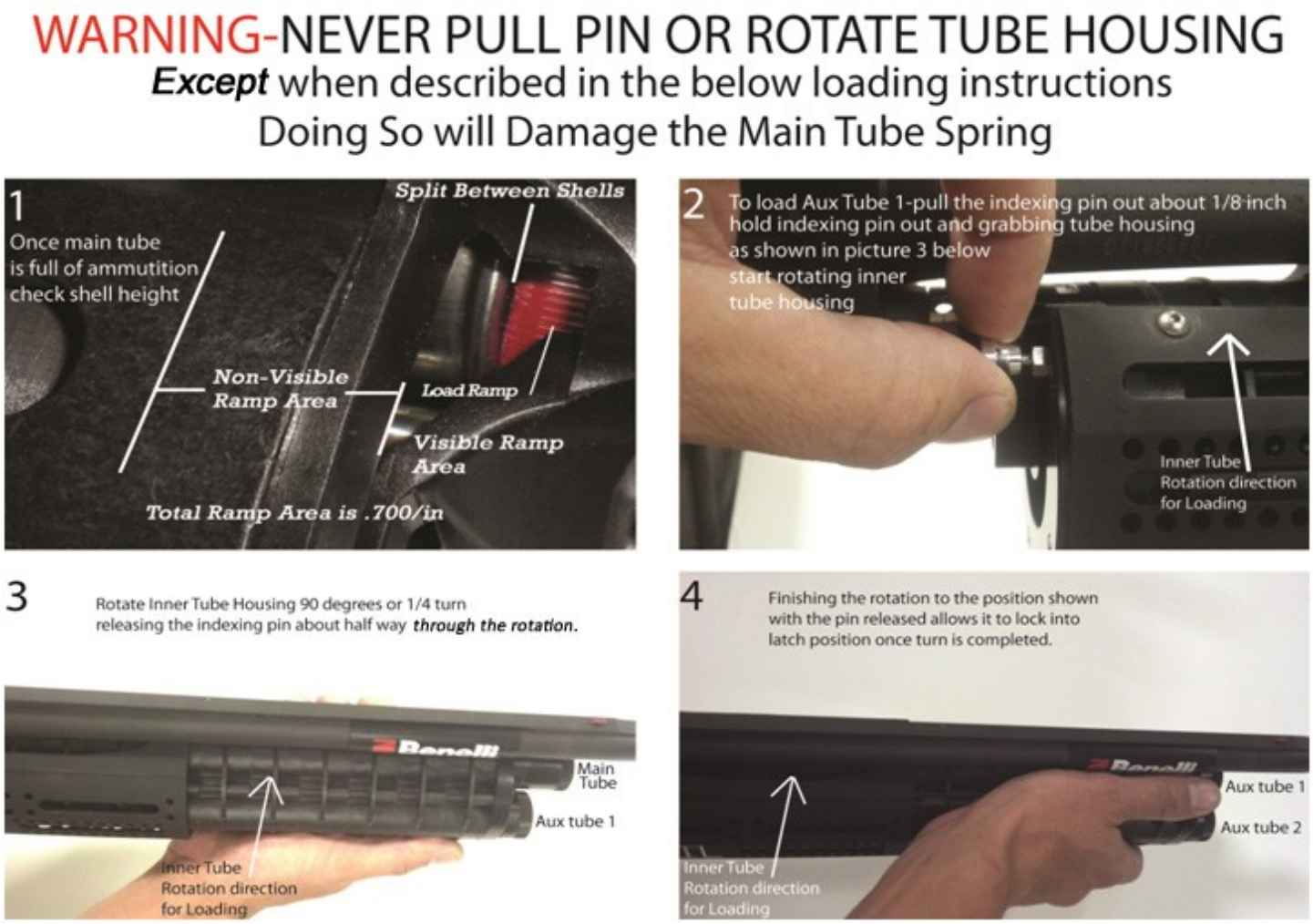
All components of the XRAIL System are made with non corrosive materials with the exception of the tube springs. All materials are High grade aluminums, 316 stainless steel, nylon and polycarbonate. All fasteners are stainless steel.

3. Loading and Unloading

WARNING! Before starting any operation on gun, make sure that the gun chamber and magazine are UNLOADED and the safety is engaged!!

Since the Benelli M2 Use and Maintenance manual is included, you will refer to it for **all safe gun handling information**. This section is only intended to explain loading and unloading of XRAIL System ammunition. For loading and unloading basics, please refer to operations section in the Benelli manual on pages 12-17.

With the **gun in a safe condition per Benelli Manual pages 1-5,** loading the XRAIL System is done by following the picture instructions 1-4 below.


WARNING-NEVER PULL PIN OR ROTATE TUBE HOUSING
Except when described in the below loading instructions
Doing So will Damage the Main Tube Spring
1
Once main tube is full of ammutition check shell height
Split Between Shells
Non-Visible Ramp Area
Load Ramp
Visible Ramp Area
Total Ramp Area is .700/in
2
To load Aux Tube 1-pull the indexing pin out about 1/8 inch hold indexing pin out and grabbing tube housing as shown in picture 3 below start rotating inner tube housing
Inner Tube Rotation direction for Loading
3
Rotate Inner Tube Housing 90 degrees or 1/4 turn releasing the indexing pin about half way through the rotation.
Main Tube
Aux tube 1
Inner Tube Rotation direction for Loading
4
Finishing the rotation to the position shown with the pin released allows it to lock into latch position once turn is completed.
Aux tube 1
Aux tube 2
Inner Tube Rotation direction for Loading

Repeat the loading sequence 3 and 4 above to load the remaining auxiliary tubes without pulling the pin during rotation. Pulling the pin is only done when rotating the main tube to Auxiliary tube 1.

When rotating tubes, there will be some resistance from the torsion spring and friction of the shells sliding up the ramp shown in picture 1 above, this is normal.

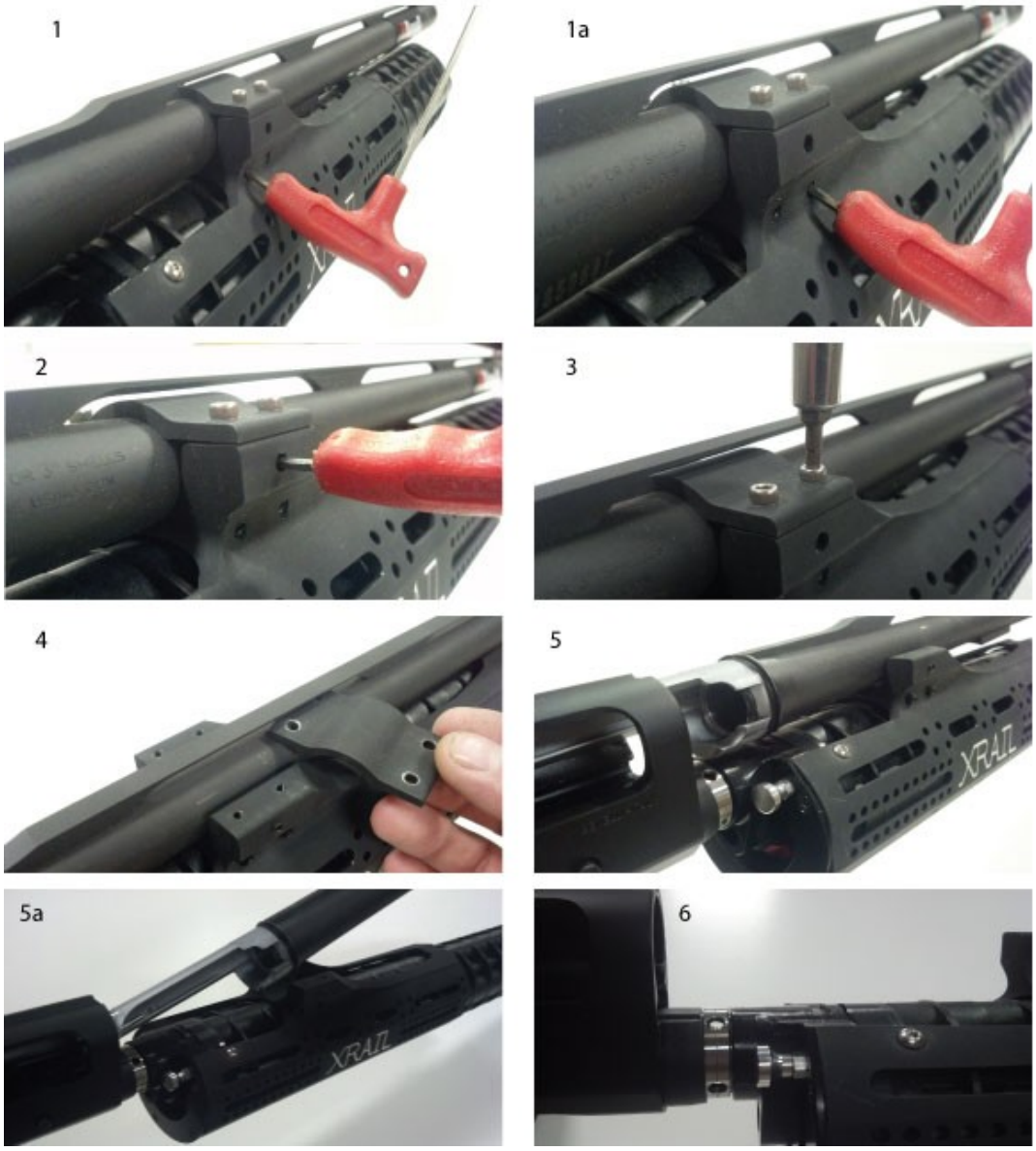
When unloading the system, whether shooting or cycling the action as described in the Benelli M2 manual, the XRAIL Systems tube housing will rotate automatically to the next string of shells until the system is empty. The first shell loaded will be the last one unloaded from the system.

4. Maintenance

WARNING! Before starting any operation on gun, make sure that the gun chamber and magazine are UNLOADED and the safety is engaged!!

A. Barrel Removal (See diagram C). To remove barrel: **1**. Loosen side angle set screws. **2**. Loosen side set screws. **3**. Remove barrel clamp screws. **4**. Remove barrel clamp. **5**. With bolt in locked open position, slide barrel out of receiver… angle barrel upwards to remove rest of the way. **6**. Note: Connection between XRAIL System and M2 receiver should be tight. During the factory install process, we seal this connection with Loctite. If it comes loose, do not reinstall barrel until you consult an RCI technician for the proper resealing process…doing so could damage the connection. At this point you can maintain bolt as described in the Benelli Manual.

Diagram C - Barrel Removal

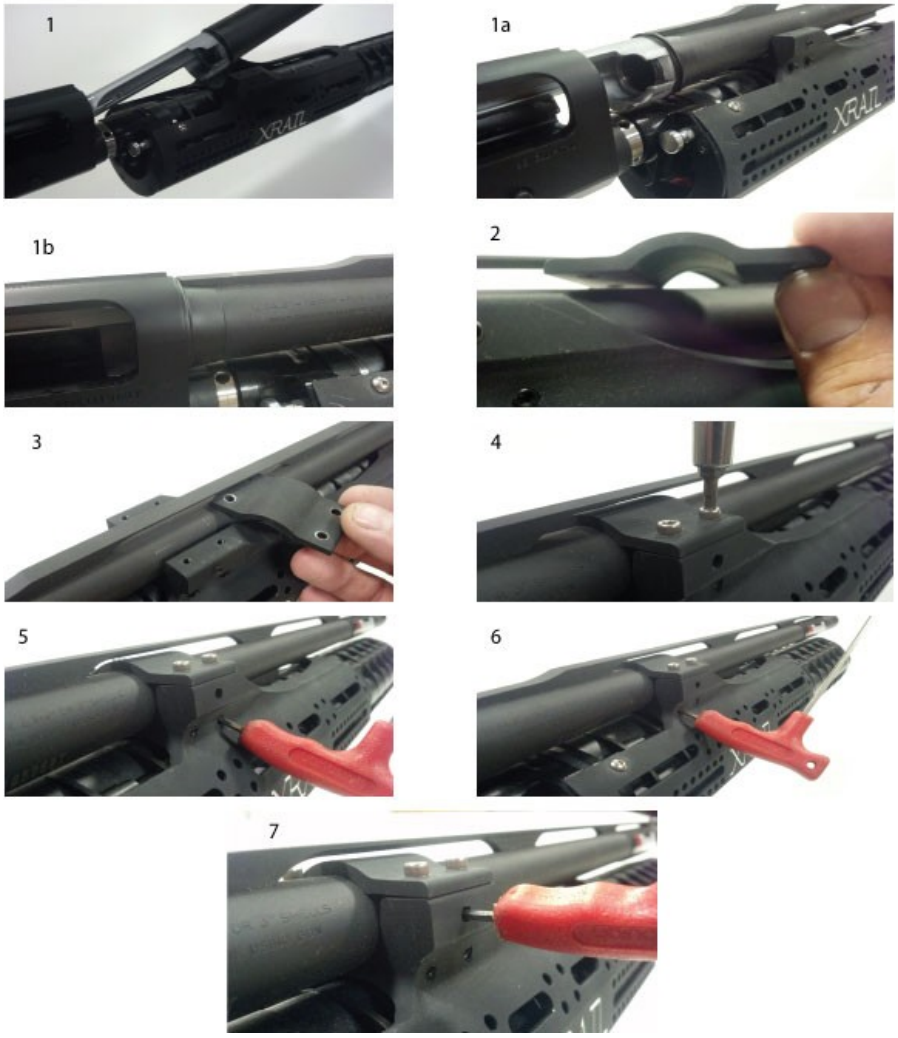


WARNING! Before starting any operation on gun, make sure that the gun chamber and magazine are UNLOADED and the safety is engaged!!

B. Barrel Installation (See Diagram D). With the bolt installed per the Benelli M2 manual, lock the bolt in the open position. Make sure to clean and re apply blue (Medium Strength non-permanent) 242 Loctite or equivalent on all threaded areas. **1**. With barrel at an angle enough to clear XRAIL System barrel clamp area, re-insert the barrel far enough so taper of barrel is narrow enough to lay barrel flat into XRAIL System Barrel clamp area. **2-3** Once barrel is fully inserted you can start installing the barrel bracket clamp. Place barrel clamp bracket on (bottom of bracket is tapered to the barrel - put large taper radius towards receiver). **4**. Insert 4 screws and tighten. **5**. Alternating side to side, tighten side angle set screws located closest to the end of the barrel; this will center the barrel over the XRAIL System Outer Housing. **6**. Tighten side angle set screws closest to M2 receiver. **7**. Tighten side set screws.

Do not over tighten any fasteners, max recommended tightness is 25 inch lbs (approximately ¼ turn once screw is set). A properly tightened barrel should be centered over the XRAIL System. The barrel should not touch the XRAIL System from the barrel clamp area to the end of the barrel. Clamping system is adjustable. By tightening, point of impact shift is possible.

Diagram D - Barrel Install



C. Inner Tube Housing Spring Replacement

WARNING! For spring removal, the following operations must be carried out carefully in order to prevent the magazine spring(s) from escaping at high speed. When carrying these operations out, always wear eye protection. If a magazine spring escapes at high velocity, severe eye injury or other injuries with serious consequences can occur. The same care must be taken during spring installation.

Within the XRAIL System inner tube housing, there are four magazine tube springs: one main tube spring held in with a threaded cap (the long cap) and three auxiliary springs held in with threaded caps (the shorter caps). The recommended steps for replacing all magazine springs is following the picture diagrams 1-5 below.

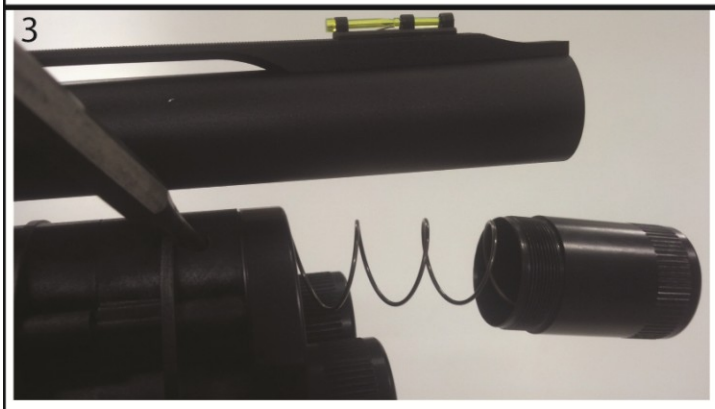
1

Clamping the firearm in a padded vice will make maintenance easier, if one is available.

2

Insert and hold punch in tube hole. This will keep spring pressure minimized while removing threaded cap.

3



Remove cap. Grab spring to contain it while you remove punch. Caution! Spring will accelerate out.

4

Insert new spring compressing it in as far as you can. Insert punch to contain spring pressure and thread cap back on.

5

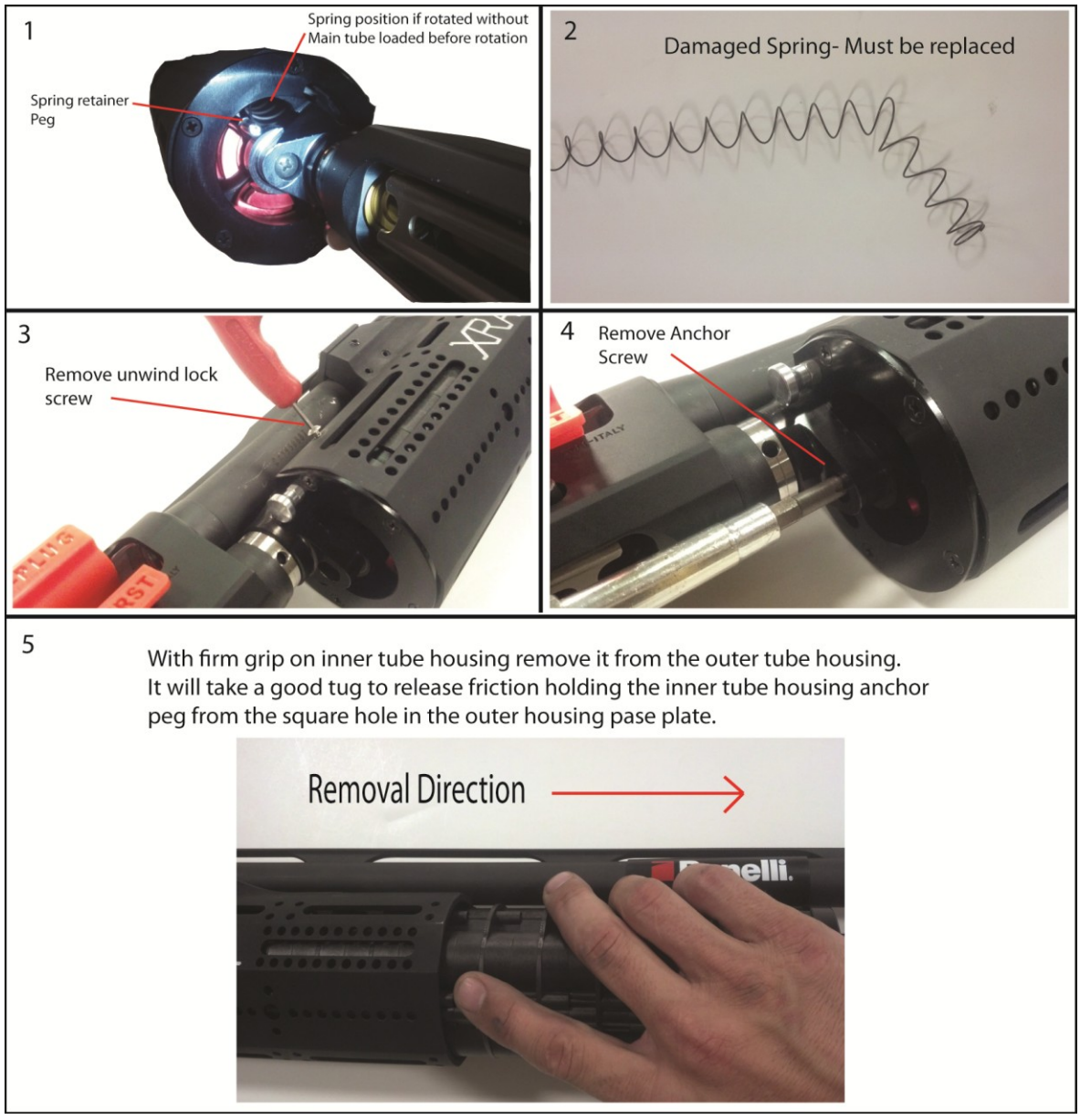
When cap is replaced, remove punch.

5. Trouble Shooting

WARNING! Before starting any operation on gun, make sure that the gun chamber and magazine are UNLOADED and the safety is engaged!!

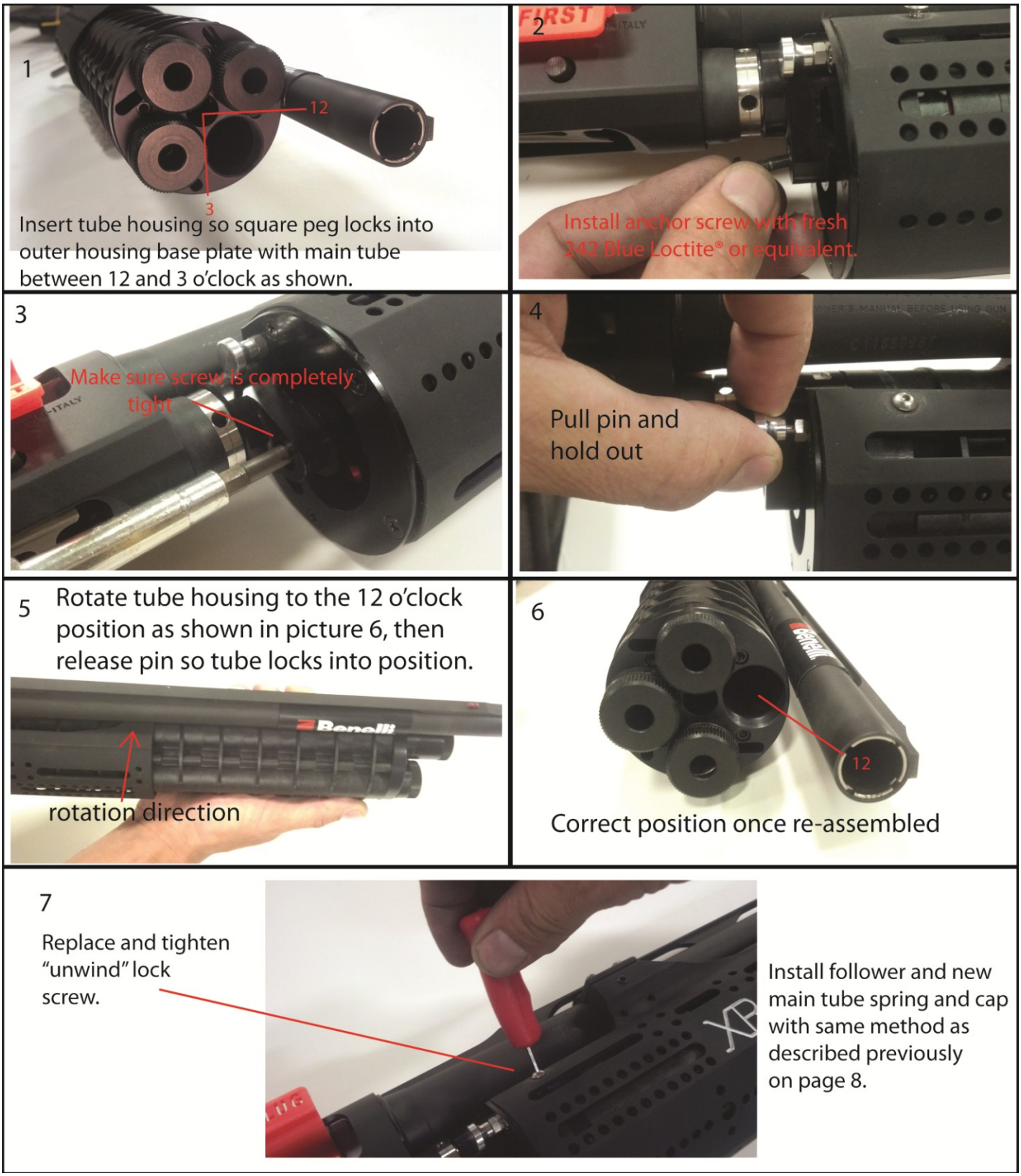
A. Resolving Damaged Main Spring From Rotating Tube Housing While Unloaded.

If tube housing is rotated and the main tube spring gets damaged or wrapped around the spring retainer peg, use the following steps to resolve the issue.


1
Spring position if rotated without Main tube loaded before rotation
Spring retainer Peg
2
Damaged Spring- Must be replaced
3
Remove unwind lock screw
4
Remove Anchor Screw
5
With firm grip on inner tube housing remove it from the outer tube housing. It will take a good tug to release friction holding the inner tube housing anchor peg from the square hole in the outer housing pase plate.
Removal Direction

At this time, remove old spring from inner tube housing and the follower from inside the outer housing near the receiver.

Next follow the picture diagrams below to properly reinstall the inner tube housing and new main spring.


1
12
3
Insert tube housing so square peg locks into outer housing base plate with main tube between 12 and 3 o'clock as shown.
2
Install anchor screw with fresh 242 Blue Loctite® or equivalent.
3
Make sure screw is completely tight
4
Pull pin and hold out
5
Rotate tube housing to the 12 o'clock position as shown in picture 6, then release pin so tube locks into position.
rotation direction
6
12
Correct position once re-assembled
7
Replace and tighten "unwind" lock screw.
Install follower and new main tube spring and cap with same method as described previously on page 8.

Now that the repairs are complete keep in mind **NEVER ROTATE UNLESS** you intend to!

B. Ammunition used and recommended by RCI during testing and competition.

Through the development of the XM2XI we have developed a list of 2 ¾" Shot Shell ammunition types that efficiently cycle the action of the gun. You are free to experiment with the thousands of combinations available as we could not possibly test them all. The list below is the US loads we have done extensive testing with and prove to be the most reliable. This is not in any way an endorsement of the said products.

SHOT SHELL

1. FEDERAL PREMIUM GOLD MEDAL PLASTIC Handicap 1235fps 1 1/8oz
2. REMINGTON STS Handicap 1235fps 1 1/8oz.
3. WINCHESTER SUPER SPORT AA (silver tab) Handicap 1250fps and up 1 1/8oz.

SLUG

1. FEDERAL GOLD MEDAL TRUE BALL REDUCED RECOIL and FULL POWER 1oz.
2. REMINGTON SLUGGER FULL POWER 1oz.

BUCKSHOT

1. FEDERAL 9 pellet reduced recoil 1325fps and up (Includes flight control).
2. REMINGTON 9 pellet FULL POWER.

Again these are only recommendations and not endorsements. Feel free to try other brands of 2 ¾" loads to find what you like the best. Thank you for your business. Roth Concept Innovations LLC (RCI) www.XRAILbyRCI.com

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